



DEPARTMENT OF
HEALTH AND WELFARE

DIVISION OF
ENVIRONMENTAL QUALITY

1410 North Hilton, Boise, ID 83706-1255, (208) 334-0502

Philip E. Batt, Governor

January 3, 1995

CERTIFIED MAIL #P 875 704 941

David W. Gottberg
Division Environmental Manager
Nestlé Brands, Potato Division
P.O. Box 1459
Moses Lake, Washington 98837

Re: Nestlé Brands (Nampa) - #9505-053-2 - Tier II Operating Permit (#027-00059)

Dear Mr. Gottberg:

On May 15, 1995, the Division of Environmental Quality (DEQ) received Nestlé Brands' (Nampa) Tier II Operating Permit (OP) application submittal. On August 25, 1995, the application was determined complete. On November 17, 1995, a proposed Tier II OP was issued for public comment. Based on review of your application, state and federal rules and regulations, and comments received, DEQ finds this project meets the provisions of IDAPA 16.01.01.400 of the Rules for the Control of Air Pollution in Idaho (Rules). Therefore, I am pleased to enclose your Tier II OP (#027-00059) for the emission sources that exist at the facility.

You, as well as any other entity, may have the right to appeal this final agency action pursuant to the Idaho Department of Health and Welfare Rules, Title 5, Chapter 3, "Rules Governing Contested Case Proceedings and Declaratory Rulings," by filing a petition with the Hearings Coordinator, Department of Health and Welfare, Administrative Procedures Section, 450 West State Street - 10th Floor, Boise, Idaho 83720-5450, within thirty-five (35) days of the date of this decision.

Please be advised that this operating permit is subject to permit application fees of five hundred dollars (\$500.00) in accordance with IDAPA 16.01.01.470 of the Rules. IDAPA 16.01.01.470 became effective on March 7, 1995. Information regarding the permit application fees will be sent to you shortly.

If you have any questions regarding the terms or conditions of the enclosed permit, please contact Brian R. Monson, Chief, Operating Permits Bureau, at (208) 373-0502.

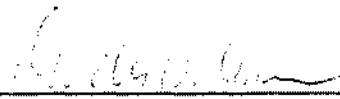
Sincerely,

Orville D. Green
Assistant Administrator
Permits & Enforcement

ODG\BRM\HE\j...permit\lweston\lwestaf.COV

Enclosure

cc: J. Palmer, SWIRO
Nelson Perry, Plant Manager (with attachments)
Source File
P. Rayne
D. Sande
COF

STATE OF IDAHO AIR POLLUTION OPERATING PERMIT GENERAL INFORMATION	PERMIT NUMBER <div style="display: flex; align-items: center; justify-content: center;"> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">0</div> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">2</div> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">7</div> <div style="margin: 0 5px;">-</div> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">0</div> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">0</div> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">0</div> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">5</div> <div style="border: 1px solid black; padding: 2px 5px; margin: 0 2px;">9</div> </div> <div style="display: flex; justify-content: space-around; margin-top: 5px;"> <div style="text-align: center;"> AQCR <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">0</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">6</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">4</div> </div> <div style="text-align: center;"> CLASS <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">2</div> </div> <div style="text-align: center;"> SIC <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">2</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">0</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">3</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">7</div> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 5px;"> <div style="text-align: center;"> ZONE <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">1</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">1</div> </div> <div style="text-align: center;"> UTM COORDINATE (km) <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">5</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">3</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">1</div> <div style="margin: 0 5px;">.</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">7</div> <div style="margin: 0 5px;">,</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">4</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">8</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">2</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">8</div> <div style="margin: 0 5px;">.</div> <div style="border: 1px solid black; padding: 2px 5px; display: inline-block;">8</div> </div> </div>	
1. PERMITTEE Nestlé Brands, Potato Division		
2. PROJECT Tier II Operating Permit		
3. ADDRESS 3704 N. Middleton Road	TELEPHONE # (509) 765-8878	COUNTY Canyon
4. CITY Nampa	STATE Idaho	ZIP CODE 83651
5. PERSON TO CONTACT David W. Gottberg	TITLE Division Environmental Manager	
6. EXACT PLANT LOCATION 3704 N. Middleton Road		
7. GENERAL NATURE OF BUSINESS & KINDS OF PRODUCTS Frozen Potato Products		
8. GENERAL CONDITIONS <p>This permit is issued according to the Rules for the Control of Air Pollution in Idaho, Section 16.01.01.400 and pertains only to emissions of air contaminants which are regulated by the State of Idaho and to the sources specifically allowed to be operated by this permit.</p> <p>THIS PERMIT HAS BEEN GRANTED ON THE BASIS OF DESIGN INFORMATION PRESENTED IN THE APPLICATION AND DEQ'S TECHNICAL ANALYSIS OF THE SUPPLIED INFORMATION. CHANGES IN DESIGN OR EQUIPMENT, THAT RESULT IN ANY CHANGE IN THE NATURE OR AMOUNT OF EMISSIONS, MAY BE A MODIFICATION. MODIFICATIONS ARE SUBJECT TO DEPARTMENT REVIEW IN ACCORDANCE WITH Section 16.01.01.200 OF THE Rules for the Control of Air Pollution in Idaho.</p>		
 ASSISTANT ADMINISTRATOR DIVISION OF ENVIRONMENTAL QUALITY		ISSUED <u>January 3, 1996</u> DATE EXPIRES <u>January 3, 2001</u> DATE

AIR POLLUTION OPERATING PERMIT

PERMIT NUMBER

PERMITTEE AND LOCATION

Nestlé Brands - Potato Division
Tier II Operating Permit
Nampa, Idaho

027 - 00059

The Permittee is hereby allowed to operate the equipment described herein subject to the emission limits and monitoring and reporting requirements specified in this permit.

SOURCE

General Process

1. SOURCE DESCRIPTION

1.1 Process Description

The facility is a potato processing plant which produces frozen processed potato products (french fries and formed products). There are two (2) processing lines:

1.1.1 Main Line;

1.1.2 Specialty Line.

The Main Line processes potatoes into french fries, while the Specialty Line processes small potatoes and potato by-product from the Main Line into formed potato products, such as cylinders, rounds, and hashbrown patties.

Raw material (potatoes) are delivered from the fields, on-site storage, or from remote storage facilities. The storage facilities provide a controlled environment to maximize potato quality. The potatoes enter the plant via truck using two (2) unloading stations, where they are cleaned and foreign debris is removed. The water used to clean the potatoes is reclaimed in a clarifier and recycled. The water soaked debris is removed. The water soaked debris from the clarifier are temporarily stored on-site. Any waste potato matter generated in the plant is sold commercially for livestock feed.

The facility utilizes natural gas fuel burning equipment for the generation of process steam for peeling, blanching, drying, frying, and air make-up units.

Point source emissions from the facility are from fuel burning equipment such as the boilers, a natural gas fired dryer, and natural gas fired make-up air heaters. Other point sources include steam powered fryers and a dryer.

Fugitive particulate emissions are also generated by receipt and transfer of raw potatoes and from paved roads.

2. OPERATING REQUIREMENTS

2.1 General Operating Requirements

2.1.1 The total raw potatoes processed shall not exceed a rate of 100,000 pounds per hour (lb/hr), or 398,500 tons per year (T/yr).

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EXPIRES: January 3, 2001

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AIR POLLUTION OPERATING PERMIT

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PERMITTEE AND LOCATION

Nestlé Brands - Potato Division
Tier II Operating Permit
Nampa, Idaho

027 - 00059

The Permittee is hereby allowed to operate the equipment described herein subject to the emission limits and monitoring and reporting requirements specified in this permit.

SOURCE

Fuel Burning Equipment

1. SOURCE DESCRIPTION

1.1 Process Description

Nestlé Brands has two (2) boilers to supply the facility's steam requirements. The Cleaver Brooks boiler provides the operational steam for the plant. The Nebraska boiler is used as a backup steam source.

The Main Line Dryer is fueled by natural gas. This dryer provides heat to drive off excess water content in the potatoes prior to the frying operation.

Make-up air units combust natural gas to provide space heating during plant operation. The emissions units listed below consist of three (3) individual make-up air units (#204, #205, #206) and an aggregate of several other smaller units (#207).

1.2 Control Description

1.2.1 Emissions from both boilers are uncontrolled.

1.2.2 Emissions from the natural gas fired dryer and all make-up air units are uncontrolled.

1.3 Equipment Specification1.3.1 Boiler #1

Manufacturer	Cleaver Brooks
Model	DL-68-WL-1097
Maximum Capacity	50,000 lbs. of steam per hour

1.3.2 Boiler #2

Manufacturer	Nebraska
Model	NS-F-84
Maximum Capacity	100,000 lbs. of steam per hour

1.3.3 Main Line Dryer

Manufacturer	National Drying
Model	1987 Carn
Rated Capacity	21.0 MMBtu/hr
Burner Type	Horizontally Fired

1.3.4 Make-Up Air Unit #204

Manufacturer	Arrovent Gas
Model	G3-32B4 Type DW
Maximum Heat Input Capacity	3.0 MMBtu/hr
Burner Type	Horizontally Fired

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AIR POLLUTION OPERATING PERMIT

PERMIT NUMBER

PERMITTEE AND LOCATION

Nestlé Brands - Potato Division
Tier II Operating Permit
Nampa, Idaho

027 - 00059

The Permittee is hereby allowed to operate the equipment described herein subject to the emission limits and monitoring and reporting requirements specified in this permit.

SOURCE

Fuel Burning Equipment

1.3.5 Make-Up Air Unit #205

Manufacturer	Arrovent Gas
Model	G60-V-604
Maximum Heat Input Capacity	6.0 MMBtu/hr
Burner Type	Horizontally Fired

1.3.6 Make-Up Air Unit #206

Manufacturer	Aladdin
Model	BA-490-DWD1
Maximum Heat Input Capacity	6.0 MMBtu/hr
Burner Type	Horizontally Fired

1.3.7 Make-Up Air Unit #207

Manufacturer	Unspecified
Model	Unspecified
Maximum Heat Input Capacity	2.0 MMBtu/hr (aggregated from all miscellaneous Make-up Air units)
Burner Type	Unspecified

2. EMISSION LIMITS

2.1 Boiler #1, #2, Main Line Dryer, and Make-Up Air Units #204, #205, #206, and #2072.1.1 Natural Gas Combustion

The particulate matter (PM) emission shall not exceed 0.015 grains per dry standard cubic foot of effluent gas adjusted to three percent (3%) oxygen by volume when natural gas is combusted (IDAPA 16.01.01.676 and 677 of the Rules for the Control of Air Pollution in Idaho). Emissions also shall not exceed any PM emission limit from the combustion of natural gas listed in Appendix A of this permit.

2.1.2 Other Criteria Pollutant Emissions

Emissions of nitrogen oxides (NO_x), sulfur dioxide (SO₂), carbon monoxide (CO), and volatile organic compounds (VOC) shall not exceed the pound per hour (lb/hr) nor the ton per year (T/yr) values listed in Appendix A of this permit.

2.1.3 Visible Emissions

Visible emissions from the exhaust stack shall not exceed twenty percent (20%) opacity over a period or periods aggregating more than three (3) minutes in any sixty (60) minute period in accordance with IDAPA 16.01.01.625 of the Rules for the Control of Air Pollution in Idaho (Rules). Opacity shall be determined using the Department's "Procedure's Manual for Air Pollution Control".

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AIR POLLUTION OPERATING PERMIT

PERMIT NUMBER

PERMITTEE AND LOCATION

Nestlé Brands - Potato Division
 Tier II Operating Permit
 Nampa, Idaho

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The Permittee is hereby allowed to operate the equipment described herein subject to the emission limits and monitoring and reporting requirements specified in this permit.

SOURCE

Fuel Burning Equipment

3. OPERATING REQUIREMENTS

3.1 Fuel Throughput Limitation3.1.1 Boiler #2 - Natural Gas

The maximum combustion of natural gas for the Nebraska boiler shall not exceed 133,000,000 cubic feet per year on an annual rolling basis.

3.1.2 The facility shall install a natural gas flow meter to monitor the annual natural gas consumption of the Nebraska boiler. The natural gas flow meter shall be installed by February 1, 1996.

3.1.3 The total natural gas consumption of all fuel burning equipment shall not exceed 1,048 million cubic feet per year (MMcf/yr), on an annual rolling basis, as per the applicant's submittal.

4. MONITORING AND RECORDKEEPING REQUIREMENTS

4.1 Operation Parameters Monitoring

The Permittee shall record the following parameters in a log to verify compliance with Section 3.1 of this permit. The log shall be kept at the facility for a minimum period of two (2) years and shall be made available to Department representatives upon request:

4.1.1 Calendar date and amount of natural gas burned, in cubic feet (cf) per month and per year.

5. REPORTING REQUIREMENTS

5.1 Exceedence Reporting of Operational Parameters

The Permittee shall submit a written report to the Department of any exceedence of the parameters specified in Sections 2 and 3 throughout this permit. The report must be post marked within five (5) days of the occurrence of the exceedence(s).

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EXPIRES: January 3, 2001

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AIR POLLUTION OPERATING PERMIT

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PERMITTEE AND LOCATION

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Tier II Operating Permit
Nampa, Idaho

027 - 00059

The Permittee is hereby allowed to operate the equipment described herein subject to the emission limits and monitoring and reporting requirements specified in this permit.

SOURCE

Process Line

1. SOURCE DESCRIPTION

1.1 Process Description**Main Line:**

Raw potatoes are washed, peeled, scrubbed, and cut to required shape and size. After blanching, the potato material undergoes drying, frying, and freezing operations prior to packaging.

Specialty Line:

The potato material for the Specialty Line consists of potatoes too small for Main Line product requirements and potato material from inspection and trimming operations. The Specialty Line process subjects the potato material to the same peeling, blanching, drying, frying, and freezing operations prior to packaging.

1.2 Equipment Specifications1.2.1 Main Line Dryer

Manufacturer	National
Model	1987 Carn
Heat Source	Natural Gas Combustion

1.2.2 Main Line Fryer

Manufacturer	Heat and Control
Model	FF-6028-5-I-3F
Heat Source	Process Steam

1.2.3 Specialty Line Dryer/Cooler

Manufacturer	Proctor Schwartz
Model	K21761
Heat Source	Process Steam

1.2.4 Specialty Line Fryer

Manufacturer	Gem Equipment
Model	1700
Heat Source	Process Steam

2. EMISSION LIMITS

2.1 Criteria Pollutant Emissions

Emissions of particulate matter (PM), particulate matter with a nominal aerodynamic diameter of ten (10) micrometers or less (PM₁₀), nitrogen oxides (NO_x), sulfur dioxide (SO₂), carbon monoxide (CO), and volatile organic compounds (VOC) shall not exceed the pound per hour (lb/hr) nor the ton per year (T/yr) values listed in Appendix A of this permit.

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PERMIT NUMBER

PERMITTEE AND LOCATION

Nestlé Brands - Potato Division
 Tier II Operating Permit
 Nampa, Idaho

027 - 00059

The Permittee is hereby allowed to operate the equipment described herein subject to the emission limits and monitoring and reporting requirements specified in this permit.

SOURCE

Process Line

2.3 Visible Emissions

Visible emissions from the exhaust stack shall not exceed twenty percent (20%) opacity over a period or periods aggregating more than three (3) minutes in any sixty (60) minute period in accordance with IDAPA 16.01.01.625 of the Rules for the Control of Air Pollution in Idaho. Opacity shall be determined using the Department's "Procedure's Manual for Air Pollution Control".

3. OPERATING REQUIREMENTS

Compliance with the throughput requirements associated with this permit shall be demonstrated by maintaining a level of operations in compliance with the following:

3.1 Hourly Facility Throughput Limitation

100,000 pounds per hour (lb/hr) (50 tons per hour) potato material (taken after dirt and rock removal).

3.2 Annual Throughput Limitation

398,500 tons per year (T/yr) potato material on an annual rolling average basis (taken after rock and debris removal).

4. MONITORING AND RECORDKEEPING REQUIREMENTS

4.1 Operation Parameters Monitoring

The Permittee shall record the following parameters in a log to verify compliance with Section 3.1 of this permit section. The log shall be kept at the facility for a minimum period of two (2) years and shall be made available to Department representatives upon request:

4.1.1 Calendar date and product throughput on a daily basis.

5. REPORTING REQUIREMENTS

5.1 Exceedence Reporting of Operational Parameters

The Permittee shall submit a written report to the Department of any exceedence of the parameters specified in Sections 2 and 3 of this permit section. The report must be postmarked within five (5) days of the occurrence of the exceedence(s).

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APPENDIX A

NESTLÉ BRANDS - POTATO DIVISION

EMISSION LIMITS^a -- HOURLY (lb/hr) AND ANNUAL^b (ton/yr)

EMISSION UNIT DESCRIPTION	PM/PM10		SO ₂		CO		NO _x		VOC	
	lb/hr	T/yr	lb/hr	T/yr	lb/hr	T/yr	lb/hr	T/yr	lb/hr	T/yr
Cleaver Brooks	0.93	4.1	0.04	0.13	2.37	10.4	9.48	41.5	0.19	0.83
Nebraska	0.68	0.34	0.08	0.36	5.42	23.8	74.47	36.6	0.19	0.84
Other Natural Gas Sources:										
Main Line Dryer	0.25	1.1			0.42	1.87	2.85	12.5	0.08	0.35
Air Make-up Units										
#204, #205, #206, #207							4.26	7.1		
Process Lines	6.9	30							12.5	55

- a. As determined by a pollutant specific promulgated U.S. EPA method, or Department approved alternative, or as determined by Department's emission estimation methods used in this permit analysis.
- b. As determined by multiplying the actual or allowable (if actual is not available) pound per hour emission rate by the actual hours per year that the process operates.

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OPERATING PERMIT GENERAL PROVISIONS

- A. All emissions authorized herein shall be consistent with the terms and conditions of this permit. The emission of any pollutant in excess of the limitations specified herein, or noncompliance with any other condition or limitation contained in this permit, shall constitute a violation of this permit and the **Rules for the Control of Air Pollution in Idaho**, and the Environmental Protection and Health Act, Idaho Code 39-101 et. seq.
- B. The Permittee shall at all times (except as provided in the **Rules for the Control of Air Pollution in Idaho**) maintain in good working order and operate as efficiently as practicable, all treatment or control facilities or systems installed or used to achieve compliance with the terms and conditions of this permit and other applicable laws for the control of air pollution.
- C. The Permittee shall allow the Director, and/or his authorized representative(s), upon the presentation of credentials:
- 1) To enter upon the Permittee's premises where an emission source is located, or in which any records are required to be kept under the terms and conditions of this permit; and
 - 2) At reasonable times to have access to and copy any records required to be kept under the terms and conditions of this permit, to inspect any monitoring methods required in this permit, and to require stack emission testing in conformance with state approved or accepted EPA procedures when deemed appropriate by the Director.
- D. Except for data determined to be confidential under Section 39-111, **Idaho Code**, all reports prepared in accordance with the terms of this permit shall be available for public inspection at the appropriate regional office of the Division of Environmental Quality.
- E. Nothing in this permit is intended to relieve or exempt the Permittee from compliance with any applicable federal, state, or local law or regulation, except as specifically provided herein.
- F. If emission testing is specified, the Permittee must schedule such testing within sixty (60) days after achieving the maximum production rate, but not later than one hundred and eighty (180) days after initial startup. Such testing must **strictly** adhere to the procedures outlined in the Department's **Procedures Manual for Air Pollution Control**, and will not be conducted on weekends or state holidays. Testing procedures and specific time limitations may be modified by the Department by prior negotiation if conditions warrant adjustment. The Department shall be notified at least fifteen (15) working days prior to the scheduled compliance test. Any records or data generated as a result of such compliance test shall be made available to the Department upon request.
- The performance tests will be performed at the maximum production rate. If this maximum rate is not achieved during testing, the allowable production rate will be limited to the production rate attained during testing.
- G. In the event of any change in control or ownership of source(s) from which the authorized emissions emanate, the Permittee shall notify the succeeding owner or controller of the existence of this permit by letter, a copy of which shall be forwarded to the Director.

ISSUED: January 3, 1996
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- H. This permit shall be renewable on the expiration date, provided the Permittee submits any and all information necessary for the Director to determine the amount and type of air pollutants emitted from the equipment for which this permit is granted. Failure to submit such information within sixty (60) days after receipt of the Director's request shall cause the permit to be voided.
- I. The Director may require the Permittee to develop a list of Operation and Maintenance Procedures which must be approved by the Department. Such list of procedures shall become a part of this permit by reference, and the Permittee shall adhere to all of the operation and maintenance procedures contained therein.
- J. The Permittee shall provide the Department a minimum of ten (10) working days' notice prior to the scheduled date of any emissions test required pursuant to this permit. The Permittee shall notify the Air Quality Bureau of any change in the testing schedule and shall provide at least one (1) working day's notice prior to conducting any rescheduled test. Any records or data generated as a result of such compliance tests shall be made available to the Department upon request.
- K. The provisions of this permit are severable; and if any provision of this permit to any circumstance is held invalid, the application of such provision to other circumstances, and the remainder of this permit shall not be affected thereby.
- L. Operation information shall include daily and annual hours of operation, and process throughput rate(s) as applied to development of permit conditions.
- M. Equipment replacement shall not constitute a modification pursuant to IDAPA 16.01.01.200 of the **Rules for the Control of Air Pollution in Idaho** only if the Permittee operates the replacement equipment in accordance with the requirements of this permit.
- N. Any records of performance tests, and any other information collected to ascertain whether limits of this permit are being met shall be kept in an easily accessible location at the permitted facility for at least two (2) years.

The Permittee shall submit a test protocol for each performance test conducted on equipment listed in this permit. The protocol shall be submitted to the Department for approval at least thirty (30) days prior to each test date. Each performance test report, including any required process data, shall be submitted to the Department within thirty (30) days of the date on which the performance test is conducted.

- O. All documents, including, but not limited to, progress reports, records, monitoring data, submitted information in support of confidentiality requests, testing reports, or compliance certifications shall contain a certification by a responsible official in accordance with IDAPA 16.01.01.123 of the **Rules for the Control of Air Pollution in Idaho**. The certification shall state that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete. The certification shall provide the signature and title of the responsible official and the date of the signature.

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EXPIRES: January 3, 2001

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